

Work Order ID 77122

November-25-11 1:41:33 PM

77122

Page 1

Item ID: D3639-4 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Doubler
 Start Date: 25/11/2011 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 09/12/2011 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/25 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3639	Rev A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3639								
2024 .066	Dwg Rev: A								
	Prog Rev: D								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

11/2-3-9

5

11/2-3-9

Sc 7/10/11

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
130									
Brake NC	Memo	0.00							
Brake NC	Form as per Dwg D3639								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									

5/12/03/15

5/12/03/15

5X0 m 12/03/15

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>81244</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

5 4 11/03/17

5 SP12-03-16

12/3/16

12-03-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-25-11 1:41:37 PM

Page 1

Work Order ID: 77122

77122

Parent Item: D3639-4

D3639-4

Parent Item Name: Doubler

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	70.1000	0.4277	1.800842			

M2024T3S 050

2024-T3 .050 sheet

**

B 12-3-9

Location

Loc Qty

Loc Code

MAT022

70.1

117684

70.1

117684



W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 77122
Description: Doubler		Part Number: D3639-4
Inspection Dwg: D3639	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	.626	2		V	IB02
Ø0.191	+0.005/-0.001	.191	6		V	
Ø0.098	+0.004/-0.001	.098	1		V	
0.45	+/-0.030	.451	2		V	
1.350	+/-0.010	1.354	2		V	
2.25	+/-0.030	2.252	1		V	
3.15	+/-0.030	3.155	2		V	
4.05	+/-0.030	4.054	2		V	
4.95	+/-0.030	4.950	1		V	
5.85	+/-0.030	5.852	1		V	
6.75	+/-0.030	6.757	2		V	
7.65	+/-0.030	7.651	2		V	
8.55	+/-0.030	8.554	2		P	ROWER
9.350	+/-0.010	9.354	1		P	
9.45	+/-0.030	9.453	2		P	
10.350	+/-0.010	10.352	2		P	
11.25	+/-0.030	11.258	1		P	
12.15	+/-0.030	12.15	2		T	IB01
12.85	+/-0.030	BEND			T	
13.86	+/-0.030	13.86	1		T	
13.96	+/-0.030	13.96	0		T	
0.805	+/-0.010	.810	2		V	
1.00	+/-0.030	.999	2		V	
2.100	+/-0.010	2.100	2		V	
3.30	+/-0.030	3.304	1		V	
2.000	+/-0.010	2.003	2		V	
2.590	+/-0.010	2.591	1		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 12-3-9	Date: 12/03/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.24	New Issue	KJ/EC/DD	

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

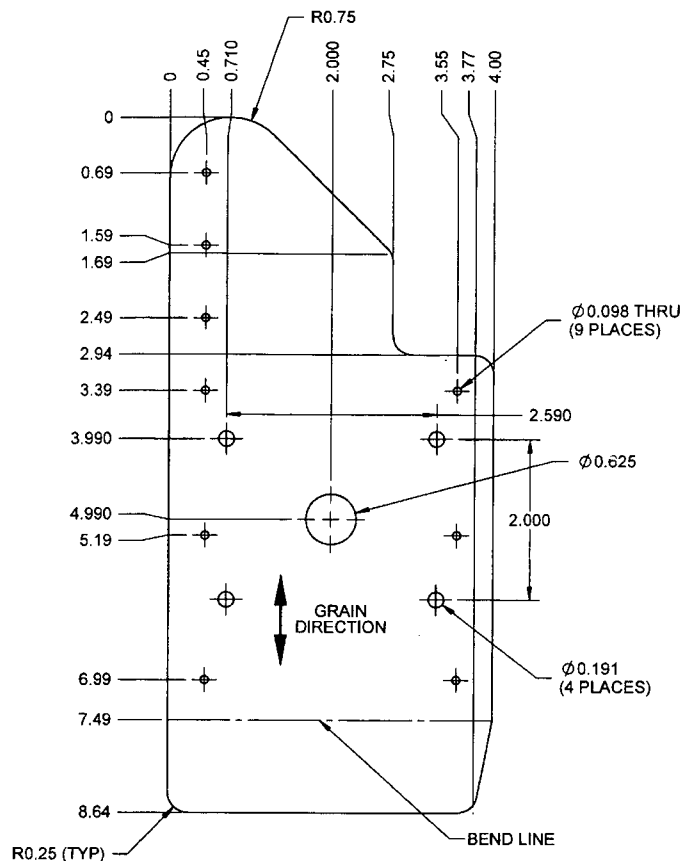
A

D

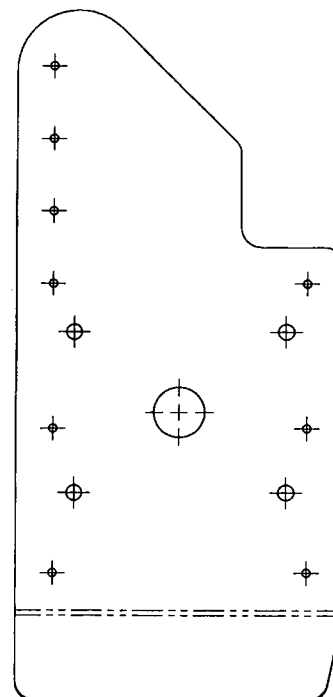
C

B

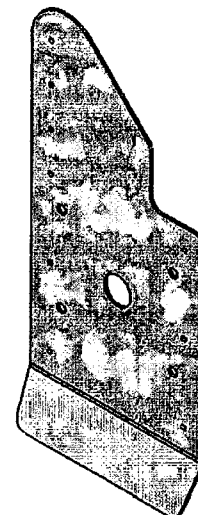
A



D3639-1F FLAT PATTERN
(D3639-2F OPPOSITE)



D3639-1 DOUBLER
(WAS GENEVA P/N G10604-3)
D3639-2 OPPOSITE
(WAS GENEVA P/N G10604-6)



STOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
NO COPY TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
77122 M.C.J
11/11/25

RELEASED
07.07.07

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs

A	NEW ISSUE: REPLACES G10604		LE	07.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC.		
DRAWN	CE	PORT HADLOCK, WA		
CHECKED	TS	DRAWING NO.	REV. A	
MFG. APPR.	TS	D3639	SHEET 1 OF 2	
APPROVED	TS	TITLE	SCALE	
DE APPR.	TS	DOUBLER	2:3	
DATE	07.07.27		COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.	
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

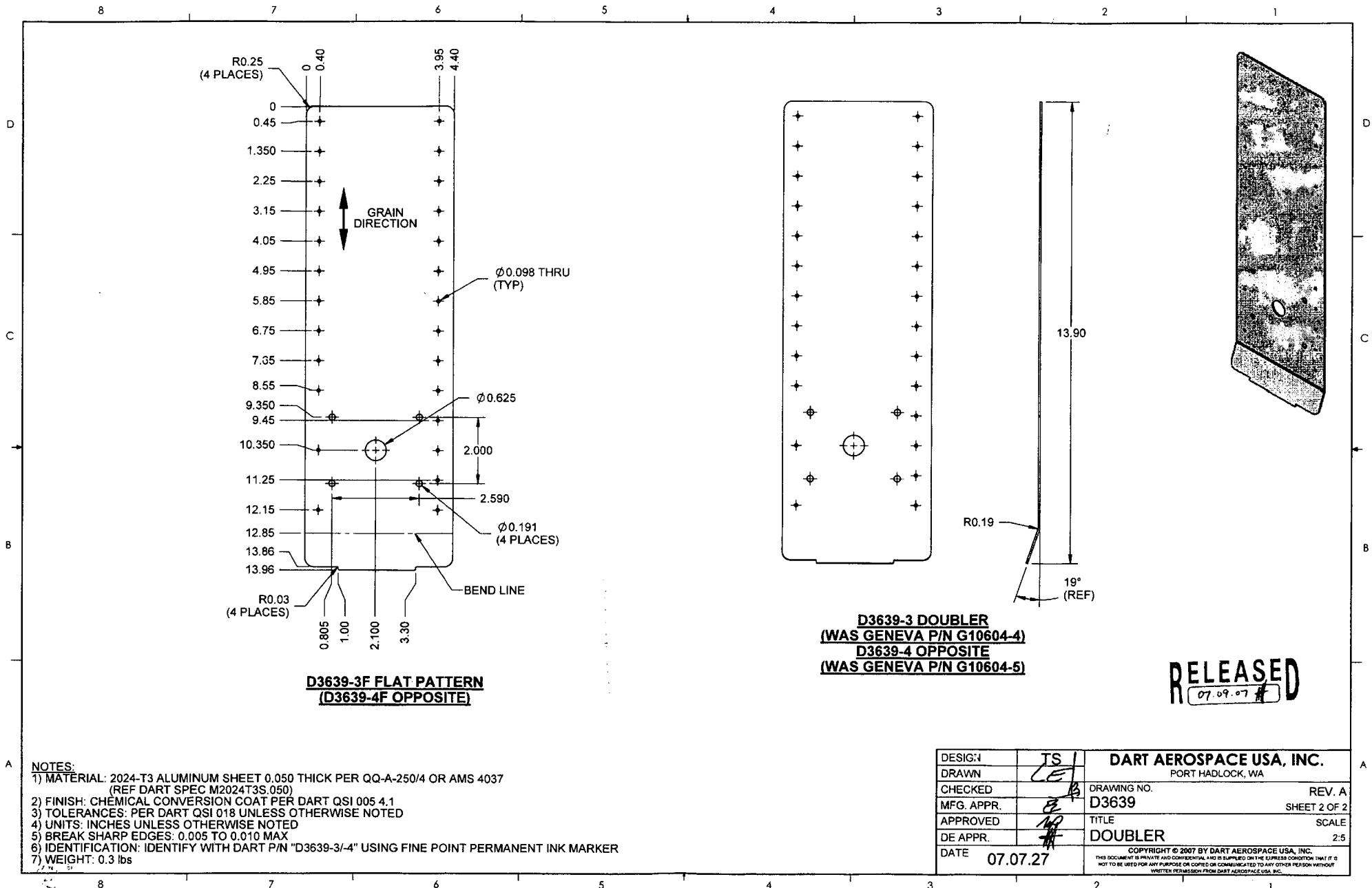
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77122



RELEASED
07-09-07

- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.3 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	CE	PORT HADLOCK, WA	
CHECKED	BE	DRAWING NO.	REV. A
MFG. APPR.	AP	D3639	SHEET 2 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	DOUBLER	2:5
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.	
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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